



7785

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6205G19232-3G

Job Sheet 186566



Part No: RBW6205G19232-3G

Job Qty: 4 pcs

Part Name: AW139 Main Rotor Scissor Bushing Replacement



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB RBW6205G19232-3G Rev 3 IPP Rev A 18.03.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	4 pcs	12/28/18		0.00	0.80	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 4	4 pcs	12/28/18		0.00	0.00	QC 4 - 26		DAS 38 9-86
							QC 4 - 28		
							QC 4 - 38		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	4 pcs	12/28/18		0.00	0.00	Packaging 3 - 1 - B4B		MLL
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		



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Container No: S148606



Part: RBW6205G19232-3G

Job No: 186566

Serial No/Batch: S148606

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 01/28/19

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	4 pcs	12/28/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op **110** - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1400-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G19232-3G-11 to RBW6205G19232-3G-9 foam as per DWG. 6-Glue foams to case and pack case as per DWG.

120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	16 Ea (4 ea)	110-Small Fab - 1	5113449
APP-1400-E	Case	4 Ea (1 ea)	110-Small Fab - 1	5146935-5146939-510
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	110-Small Fab - 1	501040
RBW6205G19232-3G-11	Placard	4 pcs (1 ea)	110-Small Fab - 1	5.139896
RBW6205G19232-3G-7	Bottom Foam use in case APP-1400-E	4 Ea (1 ea)	110-Small Fab - 1	5146934-5146938-510
RBW6205G19232-3G-9	Top Foam use in case APP-1400-E	4 Ea (1 ea)	110-Small Fab - 1	5146933-5146936-510
RBW6205G19332-3G	Main Rotor Scissor Bushing Removal Tool	4 pcs (1 ea)	110-Small Fab - 1	5148257
RBW6205G19432-3G	Main Rotor Scissor Bushing Install Tool	4 Ea (1 ea)	110-Small Fab - 1	5148549

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	16	759	0
	APP-1400-E	4	13	0
	RB41011	4	487	0
	RBW6205G19232-3G-11	4	4	0
	RBW6205G19232-3G-7	4	4	0
	RBW6205G19232-3G-9	4	4	0
	RBW6205G19332-3G	4	0	0
	RBW6205G19432-3G	4	0	0

Part Specifications

Specifications could not be found.



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/28/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	4 pcs		12/28/18	0.00	0.80	Small Fab-4		
120	QC	4 pcs		12/28/18	0.00	0.00	QC4		
130	Packaging	4 pcs		12/28/18	0.00	0.00	Packaging3-1		
140	QC21-FG	4 Ea		12/28/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G19232-3G-11 to RBW6205G19232-3G-9 foam as per DWG. 6-Glue foams to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	90-Start up Operation	
97524A032	Sealing Blind Rivet	16 Ea (4 ea)	110-Small Fab	
APP-1400-E	Case	4 Ea (1 ea)	110-Small Fab	
RBW6205G19232-3G-11	Placard	4 Ea (1 ea)	110-Small Fab	
RBW6205G19232-3G-7	Bottom Foam use in case APP-1400-E	4 Ea (1 ea)	110-Small Fab	
RBW6205G19232-3G-9	Top Foam use in case APP-1400-E	4 Ea (1 ea)	110-Small Fab	
RBW6205G19332-3G	Main Rotor Scissor Bushing Removal Tool	4 Ea (1 ea)	110-Small Fab	
RBW6205G19432-3G	Main Rotor Scissor Bushing Install Tool	4 Ea (1 ea)	110-Small Fab	

Job Allocations

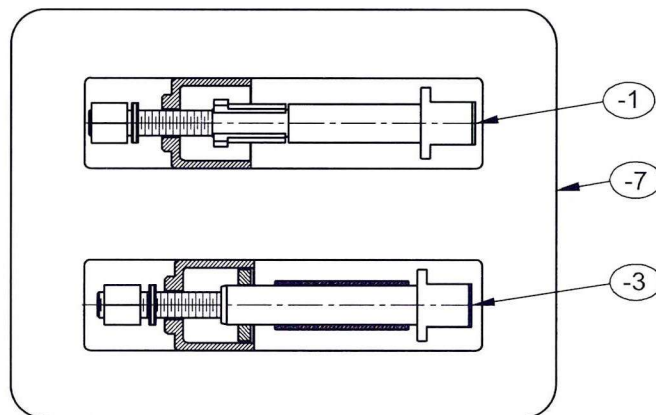
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	4	494	0
110-Small Fab	97524A032	16	478	0
	APP-1400-E	4	10	0
	RBW6205G19232-3G-11	4	4	0
	RBW6205G19232-3G-7	4	1	0
	RBW6205G19232-3G-9	4	1	0
	RBW6205G19332-3G	4	0	0
	RBW6205G19432-3G	4	0	0

Part Specifications
Specifications could not be found.

Plex 1/8/19 10:06 AM dart.lacelle.linda

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D BOTTOM FOAM DIMENSIONS TO 9.19 x 12.06, REDUCED DEPTH OF CUT-OUT TO 2.13 & CH'D RADIUS OF ALL CORNERS TO .625 PER W.P.	1/28/10	RJC	RW
2A		BROKE OUT INDIVIDUAL TOOLS, MADE THIS KIT ONLY. ADDED -9 LID FOAM PER R.W.	5/23/11	RJC	RW
3	14-0125	CH'D TITLE BLOCK WAS RED BARN IS DART. -7 CH'D SECTION A-A TO SHOW DEPTH OF BOTH CUTOITS. -9 ADDED SECTION B-B. -11 CH'D DIM WAS .06 IS (.06), WAS B/O IS IN HOUSE. -13 CH'D PLACARD WAS RED BARN IS DART, ADDED MAT'L TO BOM. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/12/14	DPD	RJC



ORIGINAL No. REF.
 RBW6205G19232 KIT No. $\equiv$ 3G6205G19232
 RBW6205G19232-1 ASSY. $\equiv$ 3G6205G19332 $\equiv$ RBW6205G19332
 RBW6205G19232-3 $\equiv$ 3G6205G19552
 RBW6205G19232-7 $\equiv$ 3G6205G19751
 RBW6205G19232-15 ASSY. $\equiv$ 3G6205G19432 $\equiv$ RBW6205G19432
 RBW6205G19232-17 $\equiv$ 3G6205G19852
 DO NOT USE, FOR REFERENCE ONLY.

FUNCTION: USED FOR REMOVAL AND INSTALLATION OF THE
 MAIN ROTOR UPPER SCISSOR LEVER ASSEMBLY BUSHINGS.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg
			-1	1	M/R SCISSOR BUSHING REMOVAL TOOL		RBW6205G19332-3G	1
			-3	1	M/R SCISSOR BUSHING INSTALL TOOL		RBW6205G19432-3G	1
		B/O	-5	1	CASE	PLASTIC	PELICAN #APP-1400-E	N/S
		B/O	-7	1	BOTTOM FOAM	Y-20 BLACK	12-1/16 x 9-3/16 x 4 I.R. SPECIALTY	2
		B/O	-9	1	LID FOAM	C200 FLAT, BLACK	1-5/32 x 9-7/64 x 12 I.R. SPECIALTY	3
			-11	1	PLACARD	PLASTIC	1/16 x 2-1/2 x 4-3/4	4
		B/O	-13	1	DART PLACARD, ON TOP OF BOX	ALUMINUM	RB41011	N/S
ASSY #	ASSY #							

DART AEROSPACE	
TITLE M/R SCISSOR BUSHING REPLACEMENT KIT	
DWG NO. RBW6205G19232-3G	REV 3
MAT'L	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/32 .XX $\pm$.01 ANGLES $\pm$.5° .X $\pm$.1	APPROVED <i>D Weil</i>
HEAT TREAT FINISH	SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA AW139
SCALE 1:4	DATE 7-8-09 SHEET 1 of 4